

Date: Tuesday, 24/02/2009 8:26:03 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D3319
Job Number	: 46033		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D33191
This Issue	: 24/02/2009 S.O. No. :	Drawing Number	: R09-014
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 03/03/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>MF 09-02-24</u>		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 QC

QUALITY CONTROL



Comment: QUALITY CONTROL

Qty 1 D3319-3 B43724 is scrap. Aft hole is torn upon installation.
 Scrap and destroy.

*** To be reworked***

2x D3319-1 original B44082
 1x D3319-3 original B43724

209-02-24

SS 09/04/24 (X3)

2.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



M1109091



Comment: HAND FINISHING RESOURCE #1

Strip the following items, and re-powder coat Grey per QSI005 4.3.5.6 => 09-04-23 (1)

2x D3319-1
 1x D3319-3

Start time: *2:30*Oven temp: *320°*Finsih time: *3:00*

BR 09-04-23 (1)

3.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/23 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D3319

Job Number: 46033

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1 *original B/N*
Identify the items with this new batch # and return to stock:

u Location: *ST 497*

5.0

QC21

FINAL INSPECTION/W/O RELEASE



u Comment: FINAL INSPECTION/W/O RELEASE
attach copy of this with each original B/N

09/04/30

Job Completion



mf
09-04-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

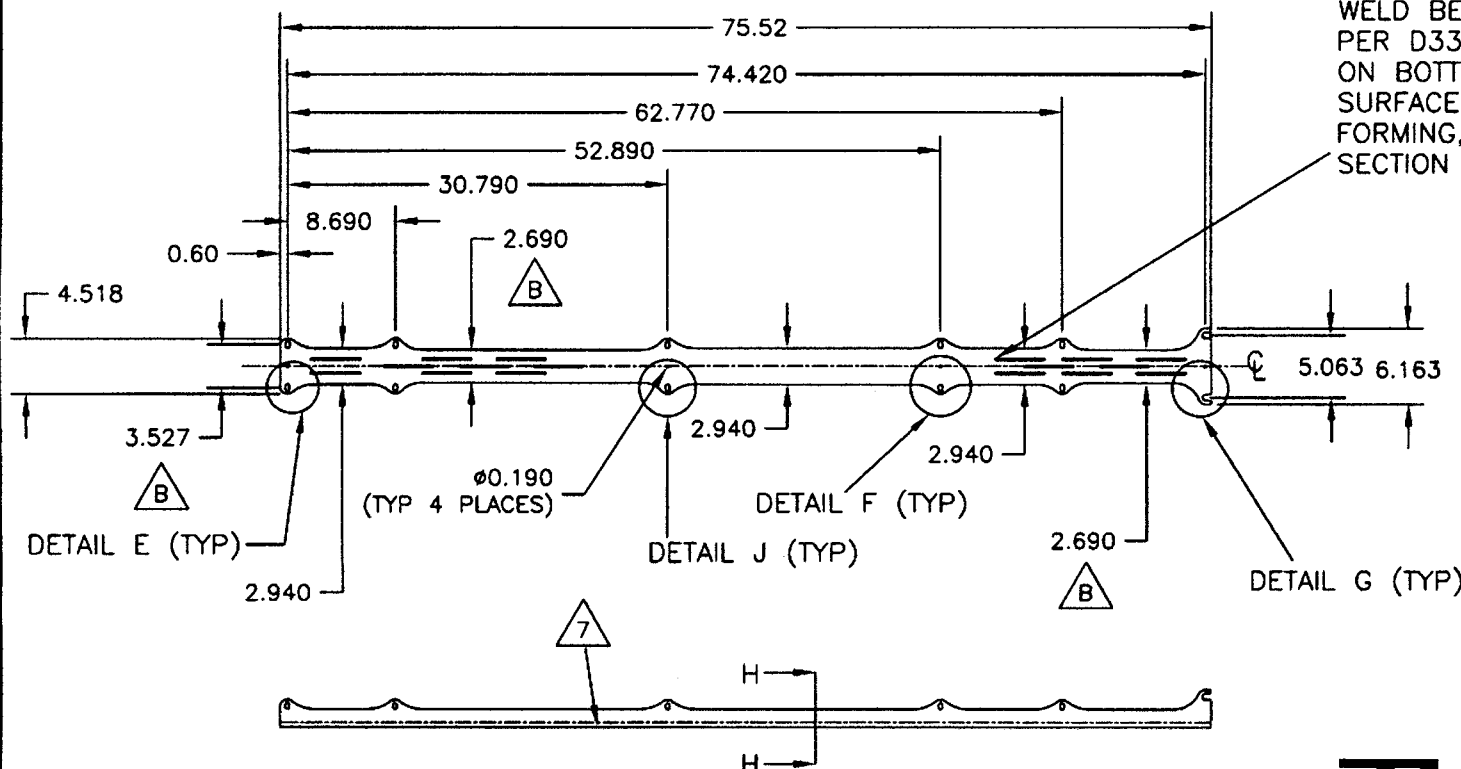
NOTE: Date & initial all entries

DART

DESIGN	BY	DRAWN BY	DART AEROSPACE LTD
CHECKED	BY	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319
		TITLE	WEARPLATE
		SCALE	1:15
		SHEET 2 OF 5	REV. B

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H

FLAT PATTERN



BENDING DETAIL

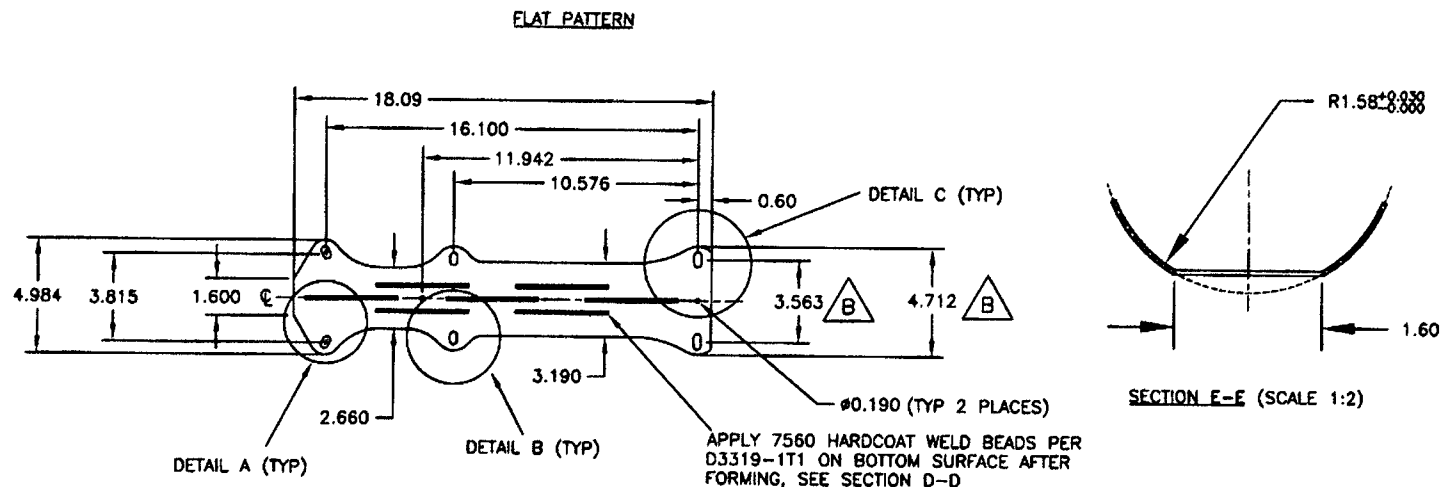
46033

D3319-3 WEARPLATE

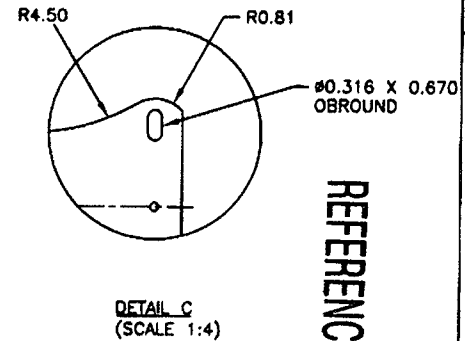
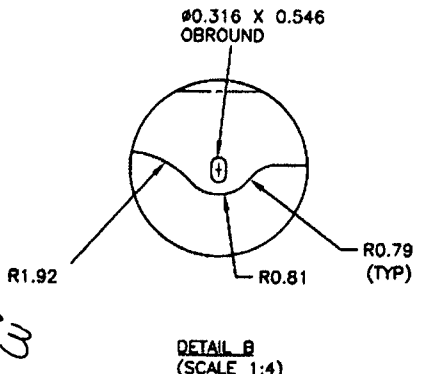
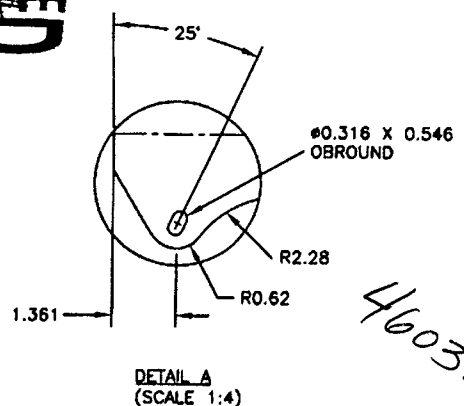
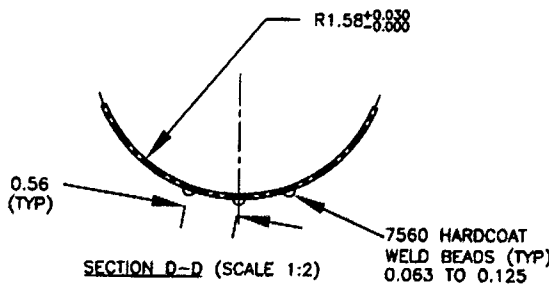
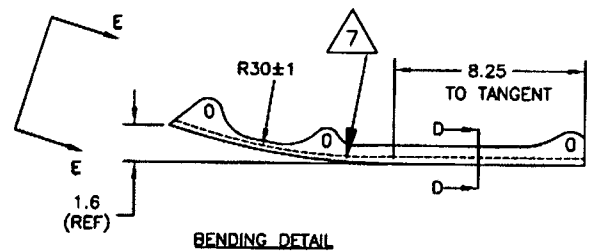
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED FOR REFERENCE ONLY

DART



RELEASED
(05 01 30)



REFERENCE ONLY

DESIGN	DRAWN BY	DART AEROSPACE LTD
P11	P11	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3319
DATE	TITLE	SCALE
05.06.06	WEARPLATE	1:8
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7

- D3319-1 WEARPLATE
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) PART IS SYMMETRICAL ABOUT CENTERLINE
 - 5) ALL DIMENSIONS IN INCHES
 - 6) WELD PER DART QSI 004
 - 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"